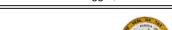
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-004022 Address: 333 Burma Road **Date Inspected:** 18-Sep-2008

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1500 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Xu Le Feng, Jiang Jian Fei No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A Yes N/A **Qualified Welders:** No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** tower skin assemblies, deck panels

Summary of Items Observed:

Tower shop - Bay 1

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: heat straightening of plates with oxy-fuel torches; oxy-fuel cutting of bevels; grinding of cover pass on stiffener to SSD1-skin B assembly and SSD1-skin D assembly; drilling of 30mm holes in stiffeners. Also present in this bay were ZPMC CWI's Xu Le Feng as well as ABF QC's Yang Yi Heng, C. K. Chan, Jiang Zi Wen. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: FCAW-G automatic cover passes with four welders southwest gantry on stiffener to ESD1-skin C assembly; flame heat straightening of ESD1-E assembly using jacks; bevel cutting of plates; SAW of skin plate and stiffeners. Also present in this bay were ZPMC CWI's Jiang Jian Fei and Zhu Zhong Hai as well as ABF QC Zhang Da Ming and Xing Xiao Guang. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed no ZPMC workers in this bay. There were 17 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)





Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer